

Split

# Work Order ID 69322 -2

Monday, May 09, 2011 8:51:05 AM



Page 1

Item ID: D3245-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 5/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

- Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3245

Rev B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Install Studs and Gromets as per Dwg D3245-3-Bond Gasket using 3M  
ADHESIVE as per Dwg D3245-A/R 3M 1300/1300L ADHESIVE  
Batch: M115230

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 ulorlu

EP 5/10/18 (8)

EP 5/10/19 (8)  
EP 5/10/11 (7x)

(7)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 69322

Monday, May 09, 2011 8:51:06 AM



Page 2

Item ID: D3245-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 5/9/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/12/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Identify as per dwg & Stock Location: 233B

0.00

Memo

0.00

Packaging

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/7/12 (7)

11/7/12

MF  
11-07-12

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Monday, May 09, 2011 8:51:11 AM

Page 1

Work Order ID: 69322

Parent Item: D3245-043

Parent Item Name: Door Assembly



Start Date: 5/9/2011

Required Date: 5/12/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev :A New Issue 07-09-11 JLM Verified By:EC  
IPP Rev:b ECN 1052 07-10-31 DD verified by:

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

127H-35

Purchased

No

100

Each

20.0000

8

48



HALF GROMMET

Location

Loc Qty

Loc Code

ST398

20

117203

20

110

Each

38.0000

8

48

2351-20-009-C3Y

Purchased

No



STUD

Location

Loc Qty

Loc Code

ST400

38

111733

12

117358

20

15447

6

110

Each

0.0000

1

6

D3245-3

Manufactured

No



Door

D3245-7

Manufactured

No



Gasket

Location

Loc Qty

Loc Code

GA

1

69041

1

369553 (7x)

Handwritten notes and signatures:

- 5/4/07/11
- M118252 (50x)
- M118261 (1x)
- 5/11/07/11
- M111733 (12x)
- M118086 (36x)
- 5/11/07/11
- 5/11/07/11

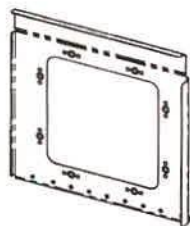
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

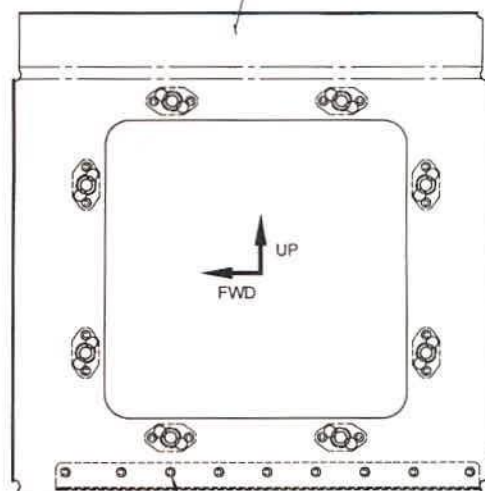
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



D3245-1  
PANEL

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)



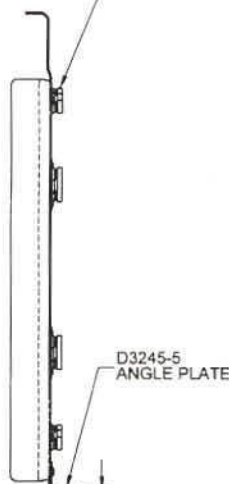
MS20615M3-3 RIVET  
(9 PLACES)

**D3245-041 ACCESS PANEL ASSEMBLY**

**RELEASED**  
17 07-10-23

**NOTES:**

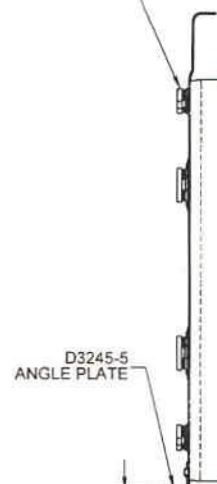
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs



0.032  
GAP

| QTY<br>-041 | QTY<br>-042 | P/N         | DESCRIPTION               |
|-------------|-------------|-------------|---------------------------|
| X           |             | D3245-041   | ACCESS PANEL ASSEMBLY, LH |
|             | X           | D3245-042   | ACCESS PANEL ASSEMBLY, RH |
| 1           |             | D3245-1     | PANEL                     |
|             | 1           | D3245-2     | PANEL                     |
| 1           | 1           | D3245-5     | ANGLE PLATE               |
| 8           | 8           | 2350-18-C3Y | DZUS RIGID RECEPTACLE     |
| 16          | 16          | MS20427M3-3 | RIVET                     |
| 9           | 9           | MS20615M3-3 | RIVET                     |

2350-18-C3Y DZUS  
RIGID RECEPTACLE (1)  
MS20427M3-3 RIVET (2)  
(8 PLACES)

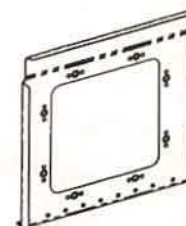


0.032  
GAP

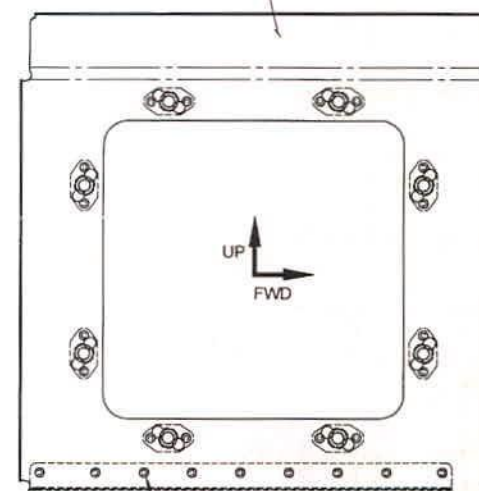
**D3245-042 ACCESS PANEL ASSEMBLY**

|            |   |  |              |
|------------|---|--|--------------|
| B          | REMOVE Ø0.204 HOLES FROM D3245-1A-1F. REMOVE MS21060-L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/-042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN P/Ns TO GASKETS & REFORMAT DRAWING | MB   | 07.10.02     |
| A          | NEW ISSUE   | RF   | 04.01.27     |
| REV.       | DESCRIPTION   | BY   | DATE         |
| DESIGN     |   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      |   | DRAWING NO.<br><b>D3245</b>  | REV. B       |
| CHECKED    |   | TITLE<br><b>ACCESS PANEL ASSEMBLY</b>  | SHEET 1 OF 7 |
| MFG. APPR. |   | SCALE<br>1:2.5   |              |
| APPROVED   |   | DATE<br><b>07.10.02</b>  |              |
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*w/b 69322*



D3245-2  
PANEL



MS20615M3-3 RIVET  
(9 PLACES)



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

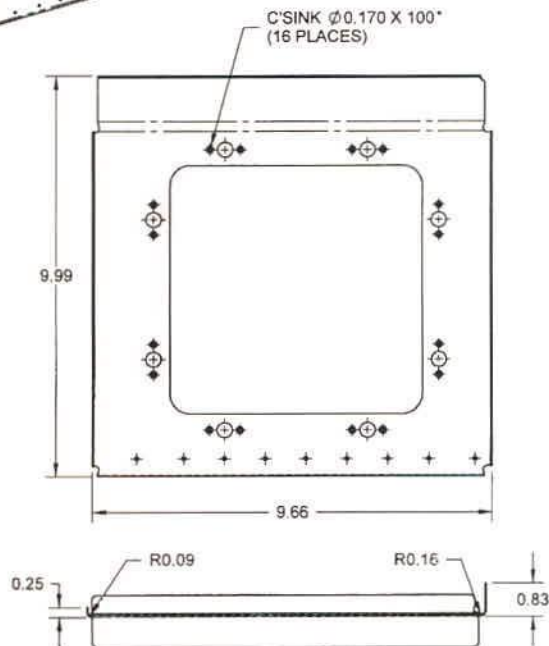
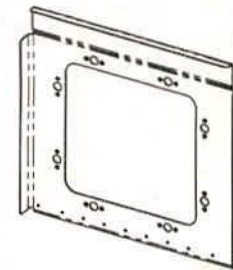
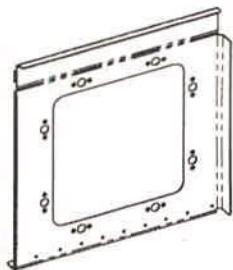
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

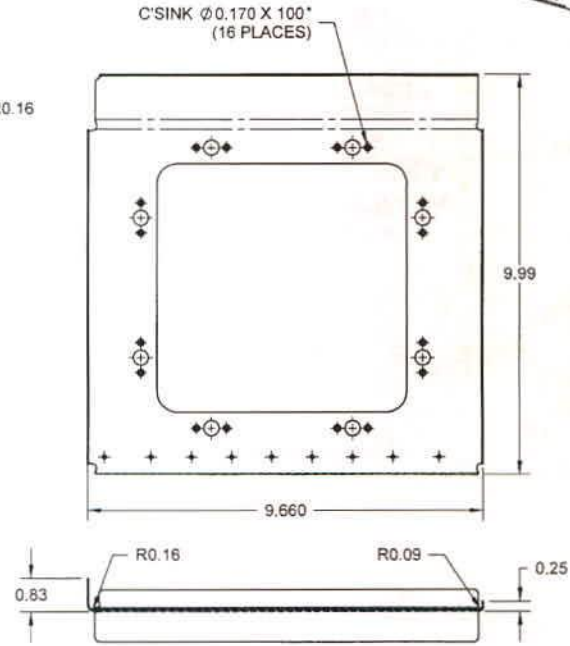
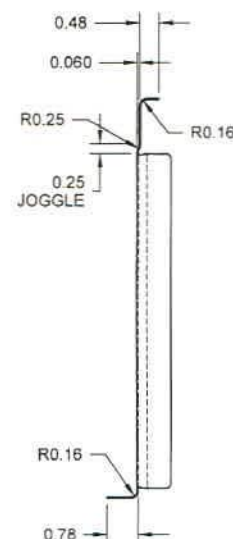
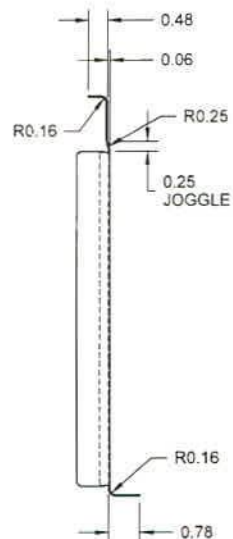
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





D3245-1 PANEL BEND DETAIL, LH



D3245-2 PANEL BEND DETAIL, RH

RELEASED  
WP 07-10-23

w/069322

- NOTES:
- 1) MATERIAL: MAKE FROM D3245-1F
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs.

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | JH       | DART AEROSPACE LTD  |              |
| DRAWN      | JH       | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    | PH       | DRAWING NO.   | REV. B       |
| MFG. APPR. | IS       | D3245   | SHEET 2 OF 7 |
| APPROVED   | NO       | TITLE   | SCALE        |
| DE APPR.   | JH       | ACCESS PANEL ASSEMBLY   | 1:3          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

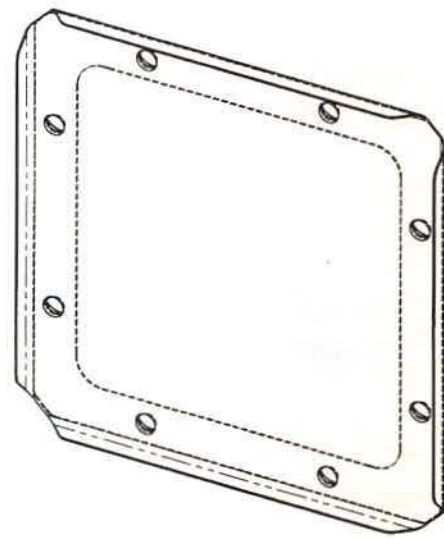
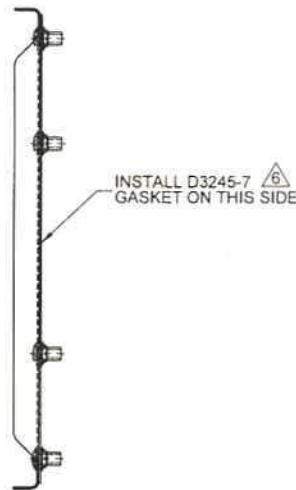
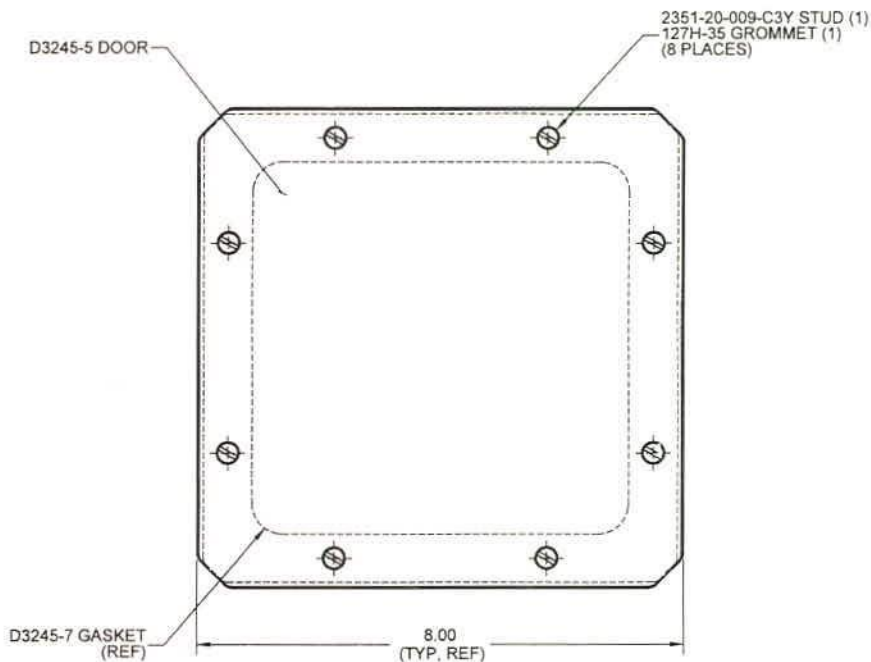
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D3245-043 DOOR ASSEMBLY**

| QTY<br>-043 | P/N             | DESCRIPTION           |
|-------------|-----------------|-----------------------|
| X           | D3245-043       | ACCESS PANEL ASSEMBLY |
| 1           | D3245-3         | DOOR                  |
| 1           | D3245-7         | GASKET                |
| 8           | 2351-20-009-C3Y | STUD                  |
| 8           | 127H-35         | GROMMET               |

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) INSTALL D3245-7 GASKET USING 3M SCOTCH-GRIP 1300/1300L ADHESIVE IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
  - 7) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
  - 8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
  - 9) WEIGHT: 0.73 lbs

**RELEASED**  
[Stamp: 07-10-02]

*w/6 69322*

|            |          |                                    |
|------------|----------|------------------------------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>          |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA        |
| CHECKED    |          | DRAWING NO. <b>D3245</b>           |
| MFG. APPR. |          | REV. B                             |
| APPROVED   |          | SHEET 3 OF 7                       |
| DE APPR.   |          | TITLE <b>ACCESS PANEL ASSEMBLY</b> |
| DATE       | 07.10.02 | SCALE 1:2                          |

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8 7 6 5 4 3 2 1

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

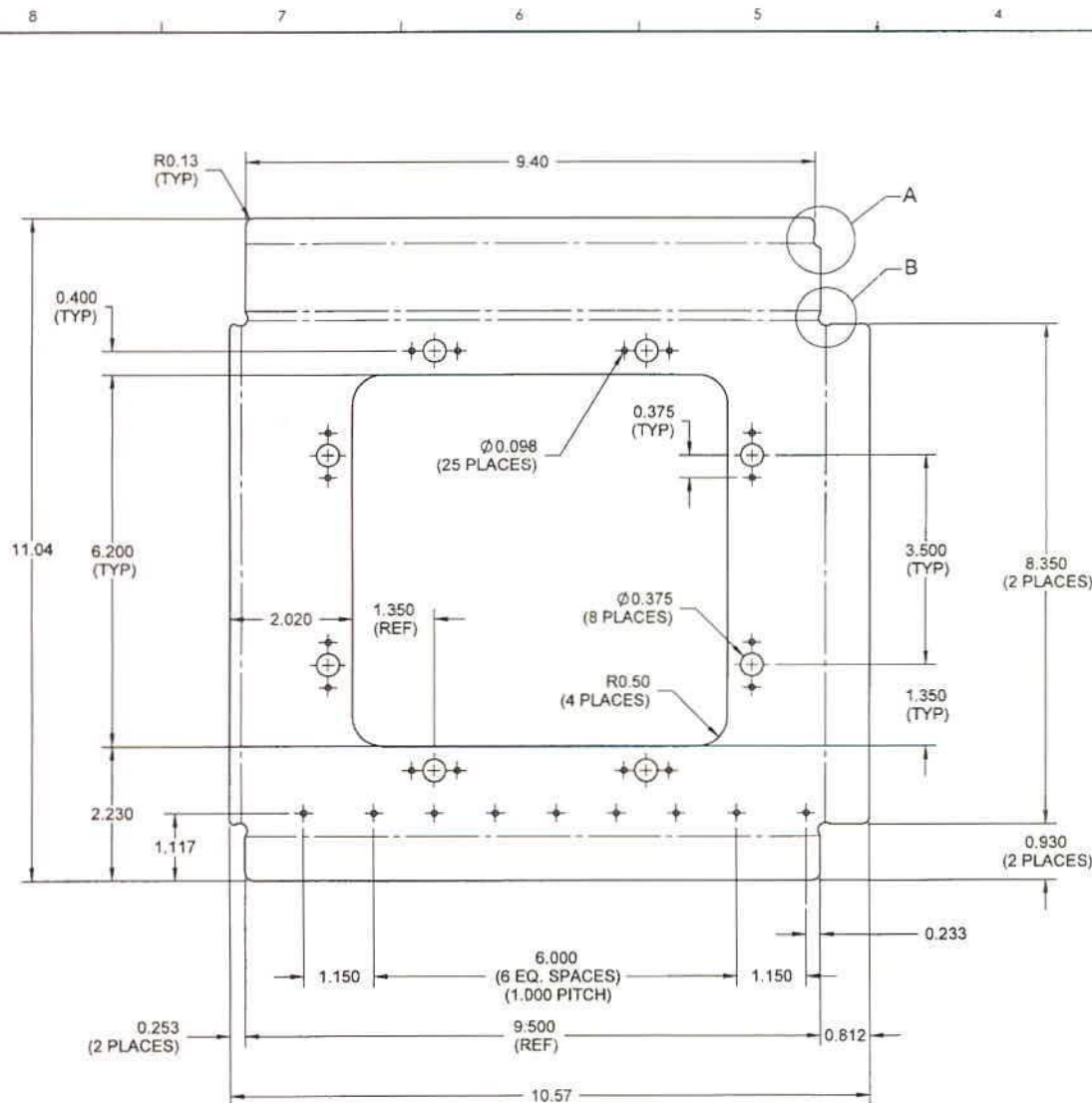
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

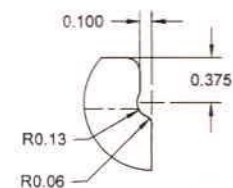
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



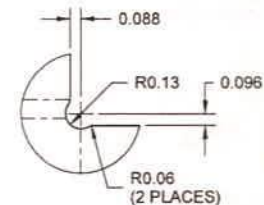


**D3245-1F PANEL FLAT PATTERN**



**DETAIL A: RELIEF**  
SCALE 1:1

*u1049322*



**DETAIL B: RELIEF**  
(TYP. 4 PLACES)  
SCALE 1:1

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.70 lbs

|            |                 |  |              |
|------------|-----------------|--|--------------|
| DESIGN     | <i>PH</i>       | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | <i>PH</i>       | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    | <i>PH</i>       | DRAWING NO. <b>D3245</b>   | REV. B       |
| MFG. APPR. | <i>PH</i>       |  | SHEET 4 OF 7 |
| APPROVED   | <i>PH</i>       | TITLE  | SCALE        |
| DE APPR.   | <i>PH</i>       | <b>ACCESS PANEL ASSEMBLY</b>   | 1:2          |
| DATE       | <b>07.10.02</b> | COPYRIGHT © 2004 BY DART AEROSPACE LTD<br><small>THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

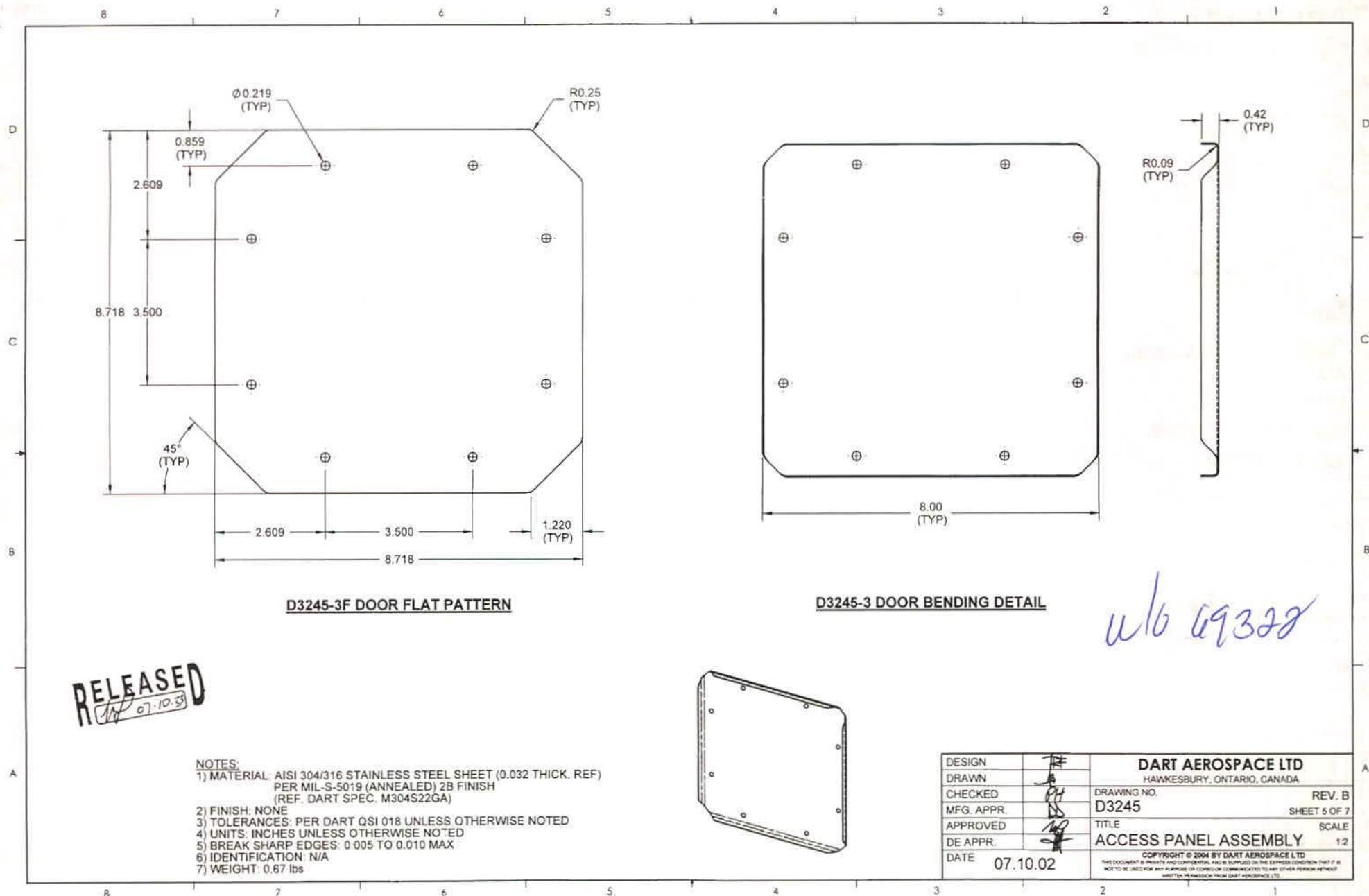
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

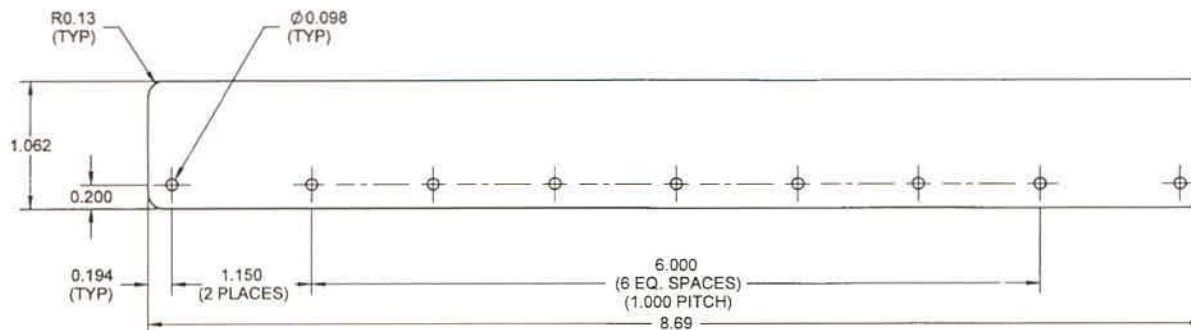
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

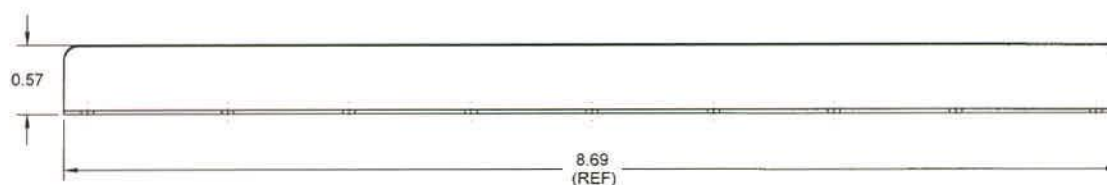
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

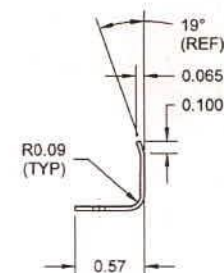




**D3245-5F FLAT PATTERN**



**D3245-5 BEND DETAIL**  
(MAKE FROM D3245-5F)



**RELEASED**  
07.10.23

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF)  
PER MIL-S-5019 (ANNEALED) 2B FINISH  
(REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.08 lbs

|   |               |  |              |
|---|---------------|--|--------------|
| DESIGN  | <del>11</del> | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN   | <del>11</del> | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED   | <del>11</del> | DRAWING NO.                            | REV. B       |
| MFG. APPR.  | <del>11</del> | D3245                                  | SHEET 6 OF 7 |
| APPROVED  | <del>11</del> | TITLE                                  | SCALE        |
| DE APPR.  | <del>11</del> | ACCESS PANEL ASSEMBLY                  | 1:1          |
| DATE  | 07.10.02      | COPYRIGHT © 2004 BY DART AEROSPACE LTD |              |
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w/b 69322

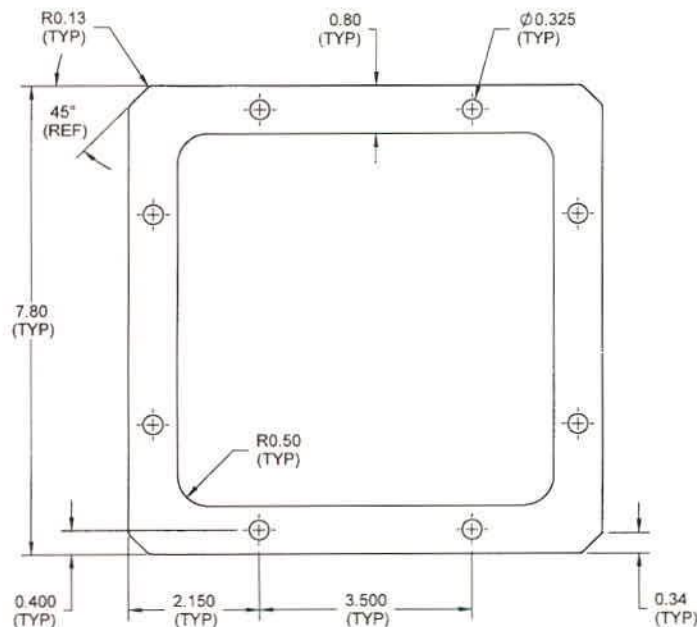
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

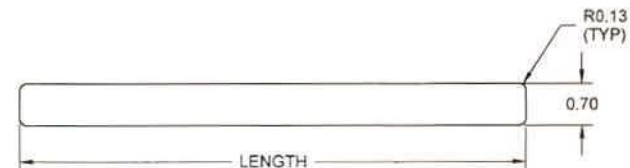
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**D3245-7 GASKET**



**D3245-X GASKET**

| P/N      | LENGTH |
|----------|--------|
| D3245-9  | 8.35   |
| D3245-11 | 9.01   |
| D3245-13 | 9.50   |

*wlo 69322*

**RELEASED**  
*07.10.02*

- NOTES:**
- 1) MATERIAL: DURABLE BLACK GASKET, 0.035 THICK (PER MIL-A-7021C OR MIL-A-17472B OR MIL-G-12803A)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

|            |           |   |              |
|------------|-----------|---|--------------|
| DESIGN     | <i>TH</i> | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      | <i>PH</i> | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    | <i>DS</i> | DRAWING NO. <b>D3245</b>  | REV. B       |
| MFG. APPR. | <i>AS</i> |   | SHEET 7 OF 7 |
| APPROVED   | <i>TH</i> | TITLE <b>ACCESS PANEL ASSEMBLY</b>  | SCALE 1:2    |
| DE APPR.   | <i>TH</i> |   |              |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries